

Work Order ID 86615

Thursday, July 05, 2012 3:38:02 PM

86615

Page 1

Item ID: D2739

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: 350 I Beam

Stop ***NS2***

Start Date: 7/5/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *2-07-05*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2739	Rev E								
100		0.00							
100	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Cut D2600-5 to length as per Dwg D2739.								
	2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739								
	3-Use uni-bit to open holes to finish size as per Dwg D2739.								
	4-Bevel Fwd end of extrusion and Deburr holes and ends.								
	5-Deburr								
120		0.00							
120	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									

4 SAD 12-07-08

W HGG 12-7-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86615***86615***

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Accept

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Start Date: 7/5/2012 Start Qty: 4.00

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Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

H 8E2/07/06

140

Identify as per dwg & Stock Location: LG

0.00

140

Packaging

Memo

0.00

Packaging

④ SMO 12-07-06

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

CK 12/7/16
YME
12-07-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, July 05, 2012 3:38:01 PM

Page 1

Work Order ID: 86615
Parent Item: D2739
Parent Item Name: 350 I Beam

Start Date: 7/5/2012
Start Qty: 4.00

Required Date: 7/19/2012
Required Qty: 4.00

Comments: IPP Rev: C02.11.28ReformatKJ
IPP Rev: D 06-03-21 As Per Rev C JLM
IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F 10.11.02 as per revE
DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No			100	Each	104.0000	1	SAD ⁴		12-07-08	
Extrusion 'I Beam' thin													

Location	Loc Qty	Loc Code
LG	104	
47814	20	
73909	84	

4

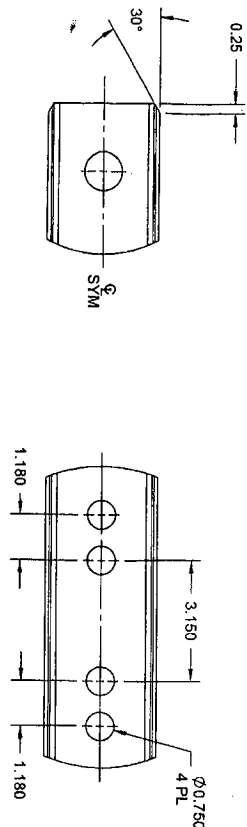
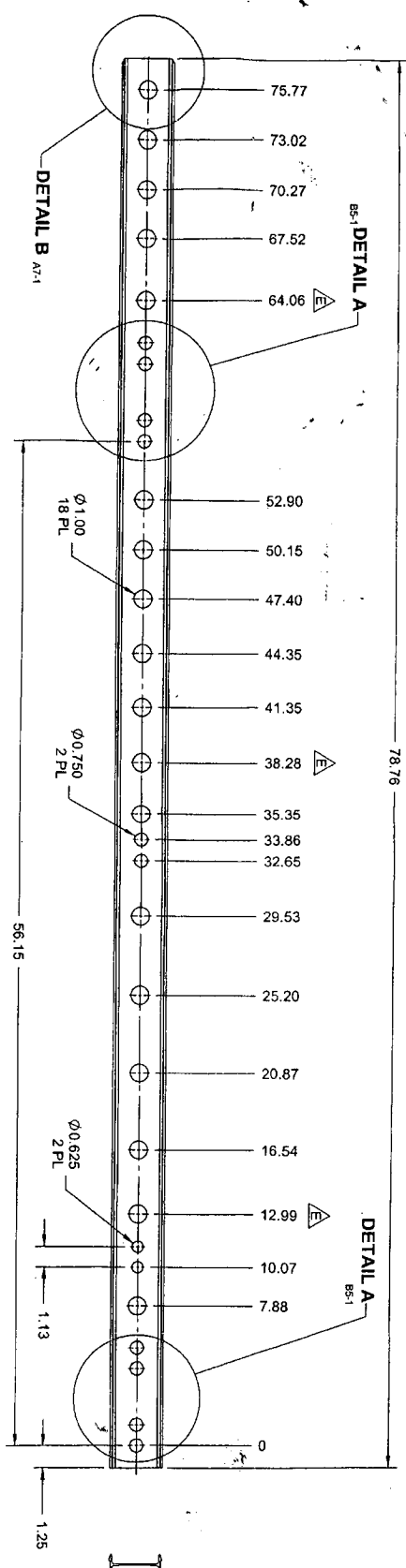
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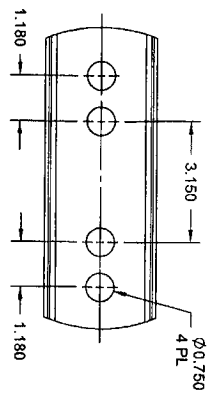
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DETAIL B
CT-1
SCALE 3X



DETAIL A
DT-1, DZ-1
SCALE 3X

- NOTES:**
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005.4.1
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART OSI 044.6.1
 - 7) WEIGHT: 3.41 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	DS	98.04.16
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRAFTER	CP	98.11.18
C	ADD BEVEL TO FWD END, ADD DETAIL B	PH	06.01.05
D	ADD BEVEL TO FWD END, ADD DETAIL B	CP	10.10.08
E	ADD BEVEL TO FWD END, ADD DETAIL B	CP	10.10.08

DESIGN	DS	DART AEROSPACE USA, INC.
DRAWN	CP	PORT HADLOCK, WA
CHECKED	CP	
MFG. APPR.	CP	
APPROVED	CP	
DE APPR.	CP	
DATE	10.10.08	

TITLE	D2739
SCALE	1 OF 1
NTS	

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RELEASED
2010-11-01

W/O:		WORK ORDER CHANGES					
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